



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3969-3

Job Sheet 199853



Part No: D3969-3

Job Qty: 30 pcs

Part Name: Spring (Basket Lid)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/3/19

Job Tracking No:

Due Date: 9/27/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per revC DD 10.03.16 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	30 pcs	9/27/19	9/27/19	0.00	0.00	Purchasing - 1	
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	30 pcs	9/27/19	9/27/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S215772



Part: D3969-3

Job No: 199853

Serial No/Batch: S215772

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/20/19

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At SEP 20 2019

				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120 QC 6	30 pcs	9/27/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	DAS
				QC 6 - 61	61
				QC 6 - 40	9-89
				QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	30 pcs	9/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	DAS
				Packaging 3 - 4 - B4B	FPool 74
				Packaging 3 - 5 - B4B	9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	30 pcs	9/27/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21

Part Op 100 - Purchasing - Issue P/O: _____ part#: SSA4/8-122-310-360N

Descriptions: 110 - Receive & Inspect for Damage & Mat'l Certs ***Measure compression only at

120 - QC6- All purchased or subcontracted products ***Measure compression only at

130 - Identify as per dwg & Stock Location: _____

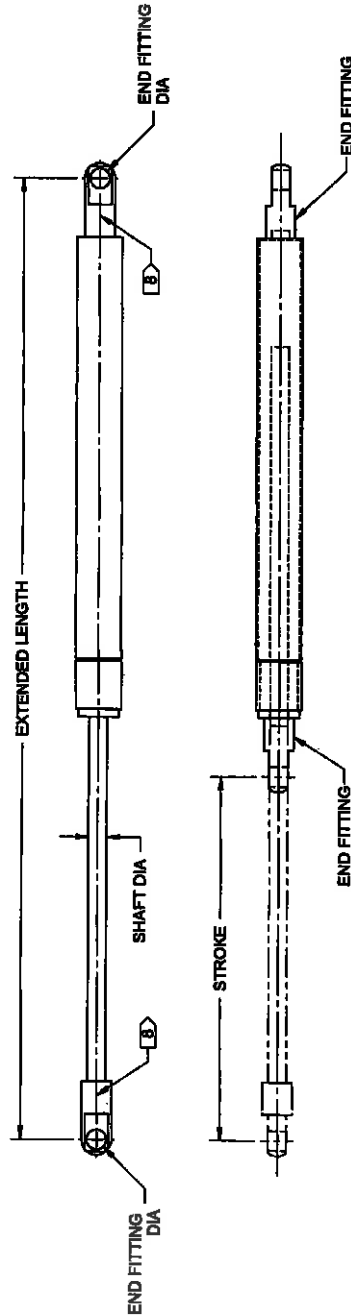
140 - QC21- Final Inspection - Work Order Release

OCT 02 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
SSA4/8-122-310-360N	Gas Spring D3969-3	30 pcs (1 ea)	100-Purchasing	5215769
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	SSA4/8-122-310-360N	30	0	0
Part Specifications				
Specifications could not be found.				

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SPECIFICATION CONTROL DRAWING



D3869-X SPRING

DART PART NUMBER	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	SHAFT DIA (mm/in)	FORCE (N/lbs)	END FITTING TYPE	END FITTING DIA (in)	CASING MATERIAL	PREFERRED SUPPLIER	SUPPLIER PART NUMBER	WEIGHT APPROX
D3869-1	122/4.80	315/12.40	60.24	310/69.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-315-310N	0.27 lbs
D3869-3	122/4.80	315/12.40	60.31	380/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-315-380N	0.32 lbs
D3869-5	122/4.80	315/12.40	60.24	133/29.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-315-133N	0.27 lbs
D3869-7	122/4.80	315/12.40	60.24	222/50.0	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-315-222N	0.27 lbs
D3869-9	130/5.12	343/13.50	60.31	380/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-130-343-360N	0.35 lbs

- NOTES:
- 1) MATERIAL: SEE CHART
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3869-X" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: SEE CHART
 - 8) CRIMP END FITTING AT APPROXIMATE LOCATION SHOWN, PER MANUFACTURERS REQUIREMENTS

RELEASED
R 2016-05-19
19-09-04

APPROVED

UNCONTROLLED
SUBJECT TO APPROVAL

D	ADDED -7/4	MIL	16.05.12
C	REWORK IN SW ADDED -3 & 4; ADDED SHAFT DIA 60.31 IN TO CHART; FORCE FOR -1 CORRECTED (WAS 60.24 IN)	JPH	10.03.04
B	DRAWING RENAMED WAS: GAS SPRING (BASKET LID).	AJS	06.11.10
A	NEW ISSUE	AJS	06.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	ML	
DRAWN	ML		
CHECKED	AJS		
MFG. APPR.	DO		
APPROVED	WM		
DE APPR.	DO		
DATE	16.05.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3869**

SHEET 1 OF 1

SCALE **NTS**

BASKET LID SPRING

PROPERTY OF DART AEROSPACE LTD
THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD
NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐		Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐		Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐		Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐	
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042)					
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ Material ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ Human Factors ☐ ☐ ☐				FAULT CATEGORY							
				Pressure/Forced ☐ ☐ ☐ Bending ☐ ☐ ☐ Crushing ☐ ☐ ☐ Cracks ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ Mislabeled ☐ ☐ ☐				Contamination ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ Fit/Function ☐ ☐ ☐			
				Power Loss/Surge ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ Weld ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐				Positioned Wrong ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ Drawing ☐ ☐ ☐ Finish ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ Misread ☐ ☐ ☐			
Other/Details:											
Completed By											
Lead hand / Supervisor											
QC / QA Coordinator											



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044361



Supplier: LST001-VC
LS Technologies Inc.
1634 Saskatchewan Ave.
Saskatoon
SK
S7K 1P6 Canada
Phone: 306 683 5000
Fax: 306 683 6403

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044361

PO Date: 9/4/19

Due Date: 9/16/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

SEP 04 2019

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199853	SSA4/8-122-310-360N			Gas Spring D3969-3 AS PER DWG D3969 REV. D	Firmed	-	9/16/19	30 pcs DAS 61 9-89	0 pcs	30 pcs	\$81.65/pcs	\$2,449.50
2	199884	B6-190-475-070N			Door Prop D3552-23 As per Dwg D3552 REV.M	Firmed	-	9/16/19	12 pcs	0 pcs	12 pcs	\$32.50/pcs	\$390.00
Grand Total:													\$2,839.50

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 9/4/19 9:20 AM Dart.Lavoie.Chantal

Packing Slip

LS TECHNOLOGIES INC
1634 Saskatchewan Ave
Saskatoon, SK S7K 1P6

P.O. No.	Date	Invoice #
POHB044361	9/9/2019	21131

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via
9/9/2019	Fed-Ex

Qty	Description
30	D3969-3 #199853 Stainless Gas Spring (SSA4/8-122-310-360N) LABELLED WITH PERMANT INK MARKER ONLY - NO LABELS
12	D3552-23 #199884 Gas Spring
Shipping Via FED EX Tracking # 776189042188	

DAS
61
9-89

RECEIVED
SEP 16 2019
DART AEROSPACE LTD.

Order checked by : 



LS Technologies Inc

1634 Saskatchewan Ave,
Saskatoon, SK S7K 1P6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

Sept 09, 2019

This is to certify that the parts listed below meets specifications as required by your order.

30 Units: D3969-3 #199853 Stainless Gas Spring

12 Units: D3552-23 #199884 Carbon Steel Gas Spring

Country of Manufacture: Canada

Date of Manufacture : September 2019

This product is ROHS compliant.

Purchase Order # POHB044361

Invoice # 21131

L S Technologies Inc Canada

A blue ink signature of Nolan Fehr, written over a horizontal line.

Nolan Fehr
President